

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD

Date: 07.08.22	Job No.: 00056	ADR Yes/No: Yes	ADR Date: 07.08.22	ECN #: 1016
Product No.: D209-669		Created By: CB	Approved By: MM	
Product Name: Bell AH-1 Skidtube Installations		Checked By: PH	General Manager Approval:	

Distribution	Reqd	Resp	Received
Production Manager	x	LL	
Production Engineering Coord	x	JLM/EC	
Director Quality Assurance			
Customer Order Processing			

Distribution	Reqd	Resp	Received
Customer Technical Support			
Marketing			
Quality	x	JM	07.09.10

Reason for Change:
Hole was removed from aft end of -041 skid on drawing; Adding Stainless Steel Wearplates

Documents Affected:
- release D2906 Rev. B
- release D3564 Rev. D
- release D3566 Rev. C
- release IIN-D209-669 Rev. B

#	Engineering Actions	Reqd	Resp	Notes	Complete
1	Required Documents/Drawings Under Review	Yes	CB/PH		07.09.07 PH
2	Update Blue/Pink/DSI Folder and Electronic Files	Yes	KJ		07.09.10 PH
3	Update D-Part/M-Drawing/DSI/DEO Master Binders	Yes	CB/KJ		07.09.10 PH
4	Update Grey Project Binder	Yes	CB/KJ		07.09.10 PH
5	Move Electronic Files	Yes	KJ		07.09.10 PH
6	Update Master Document List (MDL)	No			
7	Update Document Record (DR)	Yes	CB/KJ	Create new DR	07.09.10 PH
8	Create/Update Change Record Form	Yes	CB	-011/-012/-013/-014/-041/-043 now at CHG 002	07.09.10 PH
9	Create/Update PPP's	Yes	CB/KJ		07.09.10 PH
10	Update Controlled PDF Files	Yes	KJ		07.09.10 PH
11	Notify TC/FAA of Change	No			
12	Update QSI 021 and/or STC Approval List	No			
13	Update Product Development Summary	No			
14	Update Accpac Database	Yes	KJ	Enter new D3564-15 and D3566-15	07.09.10 PH
15	Update Access (ARC) Database	Yes	KJ	Enter new D3564-15 and D3566-15	07.09.10 PH
16	Update/Verify ARC	No			
17	Update Paperwork Kits in Production	Yes	KJ/LL	Update paperwork to IIN Rev. B for CHG 002 kits	07.09.10 PH
18	Update Qpulse/Laminated Dwgs	Yes	KJ	Update laminated D2906	07.09.11 PH
19	Update Product Compatability Matrix	No			
20	Create Eurocopter Form (FEE)	No			
21					

#	Production Actions	Reqd	Resp	Notes	Complete
22	Create/Update Coss IPP/BOM	Yes	JLM/EC		07.09.09 PH
23	Update FAI Sheets	No			
24	Create/Update CNC Programs	Yes	JLM/EC	Create waterjet program for new -15 parts	07.09.09 PH
25	Create/Update Tooling	No			
26	Red Tag Stock (Specify)	Yes	DT/JM	Ensure D209-669-041 B/N 21980 is quarantined	07.09.10 PH
27	Rework/Scrap Current Production and/or Stock	Yes	LL	Rework D209-669-041 B/N 21980 per NCR 083	07.09.11 PH
28	Update Paperwork Kits in Stock	Yes	KJ/LL	Update paperwork to IIN Rev. B for CHG 002 kits	07.09.11 PH
29	Create/Update MPP	No			
30					

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
31	Notify Previous Customers	No			
32	Notify Eurocopter France	No			
33					

Description / Action: 07-011
 - D209-669-041 B/N 21980 skids must be reworked per W/O 026844 (ref NCR 083) 1 IN PROD.
 - Rework stocked D209-669 kits with new D3564 SS wearplates and D3566 gaskets. 1 IN STOCK (B 22797) - 043
 WILL STAY AT CHG 001! 07.09.10 PH

Date: Thursday, 07/12/2006 3:12:25 PM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.

Drawing Name : D209-669-041

Job Number : 29844

Estimate Number : 10804

P.O. Number :

Part Number : D209669041

This Issue : 07/12/2006

S.O. No. :

Drawing Number : REWORK-NCR083

Prsht Rev. : NC

Project Number :

First Issue : 1/1

Type : LANDING GEAR

Drawing Revision :

Previous Fun : 00015

Material :

Due Date : 14/12/2006

Qty: 1 Um: Each

Written By :

Checked & Approved By :

Comment :

REFERENCE ONLY

Additional Product

Job Number :

Seq. #:

Machine Or Operation:

Description :

1.0

D209669041

Skidtube Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Skidtube Assembly

B/N: 23780

2.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

DISASSEMBLE ALL HARDWARE;

1 X D2855 CAP

1 X D2577-3

1 X D2577-5

1 X D2577-7

12 X PLUGS

ALL BOLTS & HARDWARE - (DISCARD HARDWARE)

3.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

GRIND AND REMOVE PAINT AND ALODINE FROM AFT TOW RING HOLE INSIDE & OUT

~~PLACE A COPPER BACKING ON THE INSIDE OF THE HOLE, AND FILL THE 0.640" WITH WELD ON BOTH SIDES OF TUBE~~

FABRICATE (2) Aluminum Plugs to plug the holes
 MATERIAL M104182

WELD IN PLACE PER QSI 004 AND GRIND FLUSH

ON BOTH INSIDE AND OUTSIDE OF TUBE. BE 07-08-08

~~ALUM RODS~~
~~GRIND WELD FLUSH~~

Stock	Prod
669-011- 0	0
-012-	0
-013-	0
-014-	0
-041	1 (B29844)
-043	0

Kim Johnston

From: L Lacelle [llacelle@dartaero.com]
Sent: Tuesday, September 11, 2007 7:01 AM
To: 'Kim Johnston'
Cc: 'Peter Hum (E-mail)'; 'Jason Murdoch (E-mail)'
Subject: RE: D209-669-041 B29844 and one D209-669-043 B22797 in stock

I do not want to spend the time on this one tube that has been sitting in
stk for the longest time. Let it stay at chg 001
LL

-----Original Message-----

From: Kim Johnston [mailto:kjohnston@dartaero.com]
Sent: September 10, 2007 4:19 PM
To: 'L Lacelle'
Cc: Peter Hum (E-mail); Jason Murdoch (E-mail)
Subject: RE: D209-669-041 B29844 and one D209-669-043 B22797 in stock

I spoke to Peter about it. If you are not going to replace with SS
wearplates it has to stay at CHG001 and can only be sold as is as -043 or
with the -013/-014 at CHG001. Otherwise all the parts have been put up to
CHG002. Jason will have to re- redtag the batch (22797) with this info.
Let me know what you're going to do with it.

Kim

-----Original Message-----

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Monday, September 10, 2007 3:28 PM
To: 'Kim Johnston'
Subject: RE: D209-669-041 B29844 and one D209-669-043 B22797 in stock

Why would I be re-working the -043, the ecn does not mention it...????

-----Original Message-----

From: Kim Johnston [mailto:kjohnston@dartaero.com]
Sent: September 10, 2007 3:21 PM
To: Linda Lacelle (E-mail)
Subject: D209-669-041 B29844 and one D209-669-043 B22797 in stock

Linda,

I show one D209-669-041 B29844 and one D209-669-043 B22797 in stock that
will need new paperwork and labels. The -041 is being re-worked at the
moment and the -043 is red tagged. When you pull the -043 to re-work it
can you tell me what batch # so that I can re-do the labels please.

Kim Johnston
Dart Aerospace Ltd.
Engineering Clerk
Document Control
Email: kjohnston@dartaero.com
Tel: 613-632-5200
Fax: 613-632-9311

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33					

Description / Action:

- 07 - 011 329844
- D209-669-041 B/N 21980 skids must be reworked per W/O 025844 (ref NCR 083)
 - Rework stocked D209-669 kits with new D3564 SS wearplates and D3566 gaskets.